

Date: Wednesday, 4/19/2006 7:36:55 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 26709					
Estimate Number	: 10393					
P.O. Number	: N/A			Part Number	: D31461	
This Issue	: 4/19/2006 S.O. No. : N/A			Drawing Number	: D3146 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A Type : MACHINED PARTS			Drawing Revision	: A	
Previous Run	: 24684			Material	: N/A	
Written By	: <u>SGA COMMENT BELOW</u>			Due Date	: 5/5/2006	
Checked & Approved By	: <u>KJL 06/04/14</u>			Qty:	10	Um: Each
Comment	: Est A04.04.28 New issue KJ/JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"	
		Comment: Qty.: 0.2932 f(s)/Unit Total : 2.9316 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick (M6061T6B1.250x04.500) Batch: M13655	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 4.500" x 1.250" x 3.100" long Bar	<u>S. 06/04/25 +10</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA419 and Dwg D3146 Identify as D3146-1	<u>JL 06/04/26 10</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>JL 06/04/26 10</u>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>JNL 06/04/26 10</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/04/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/12	3	- 2 parts scraped - parts lifted while machinging on 3rd op. - dimension .125 is under by .015	<u>SB</u> <u>06/04/12</u>	script replace	SL 06/04/12	<u>SB</u> 06/04/12	<u>MB</u> 06/04/12	<u>FB</u> 06/04/12

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 7:36:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 26709

Part Number: D31461

Job Number:



Seq. #:	Machine Or Operation:	Description :	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr and Tumble	JL 06/05/01 (10)	
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	a.m 06-05-01 (10)	
8.0	POWDER COATING	POWDER COATING	
	Comment: POWDER COATING Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	DL 06/05/01 (10)	
9.0	Q95	INSPECT WORK TO CURRENT STEP	
	Comment: Inspect work to Step 9	JL 06/05/02 (10)	
10.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 Identify and Stock	AP 06/05/02 (10)	
	Location: ST410		
11.0	DC	DOCUMENT CONTROL	
	Comment: DOCUMENT CONTROL Inspection Level 21	(10) 06/05/02	
	Job Completion	u 06/05/02	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26709
Description: Bracket	Part Number:	D3146-1
Inspection Dwg: D3146 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.010	3.004	/			
2.000	+/-0.010	1.998	/			
0.230	+/-0.010	.232	/			
0.425	+/-0.010	.425	/			
3.420	+/-0.010	3.423	/			
2.535	+/-0.010	2.536	/			
0.221	+/-0.010	.220	/			
0.391	+/-0.010	.388	/			
0.221	+/-0.010	.220	/			
0.850	+/-0.010	.850	/			
R0.350	+/-0.010	.350	/			
0.850	+/-0.010	.850	/			
0.221	+/-0.010	.220	/			
0.491	+/-0.010	.488	/			
0.125	+/-0.010	.130	/			
1.025	+/-0.010	1.022	/			
R0.375	+/-0.010	.375	/			
28°	+/-0.1°	28°	/			
0.276	+/-0.010	.286	/			
0.925	+/-0.010	.919	/			
R0.125	+/-0.010	.125	/			
4.345	+/-0.010	4.346	/			
0.125	+/-0.010	.129	/			
93°	+/-0.1°	93°	/			
R0.125	+/-0.010	.125	/			
Grain Direction	N/A					

Measured by:	JL	Audited by:	JNL	Prototype Approval:	N/A
Date:	06/04/26	Date:	06/04/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	JNL

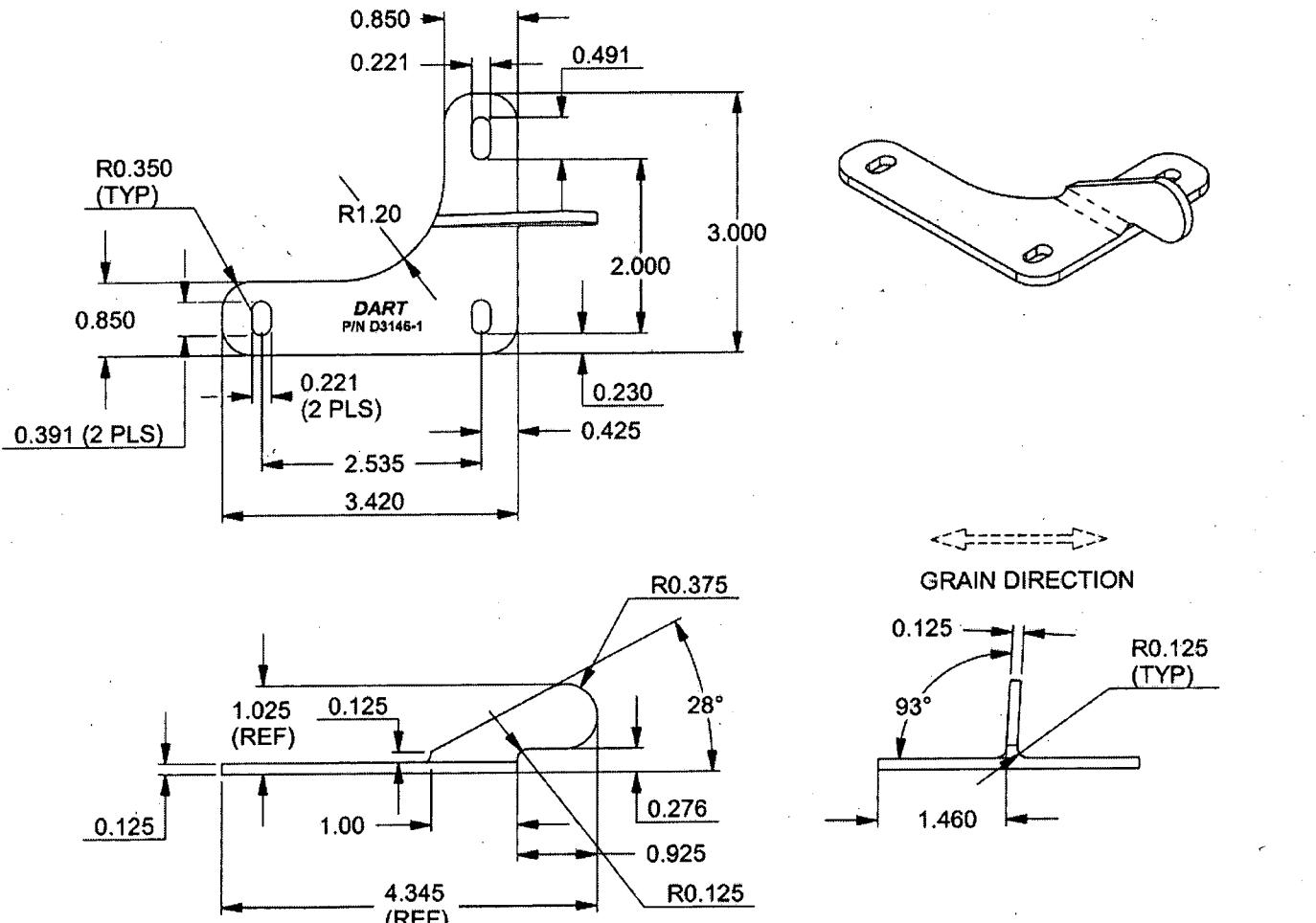
**DART**

DRAFT COPY ISSUED

DESIGN <i>[Signature]</i>	DRAWN BY <i>RF</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3146
DATE 02.04.25	TITLE BRACKET	REV. A SHEET 1 OF 1 SCALE 1:2

RELEASED  
02.05.27 *[Signature]*

A 02.04.25 NEW ISSUE



D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27  
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPECN M6061-T6B)
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *26709*

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